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RBT18520

Job Sheet 201768



Part No: RBT18520

Job Qty: 1 pcs

Part Name: Main Rotor Damper Load Test Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 11/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520 Rev Q IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP/IPP Rev. B 19.02.22 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/20/19		0.00	0.33	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		GP19-10-25
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	11/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		OCT 30 2019
							QC 5 - 61		
							QC 5 - 81		
120	External Load - 2 - B4B	1 pcs	11/20/19		0.00	1.00	External Load - 1 - B4B		
							External Load - 2 - B4B		
							External Load - 3 - B4B		

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125 QC 5

1 pcs

11/20/19

0.00 0.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

N/R

130 Packaging 3-1 - Stock - B4B 1 pcs

11/20/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS
28
9-89

140 QC 21 - FG

1 pcs

11/20/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

DAS
21 OCT 31 2019
9-89

RBD1

Part Op 100 - Assemble as per drawing. See note 2,3,4, and 5.

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

120 - 1-Load test as per drawing sheet 15. 2-Engrave -11 as per drawing sheet 11 note 1 using MARKTRONIC engraver.

125 - QC5- Inspect part completeness to step on W/O

130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - (QC21- Final Inspection - Work Order Release)

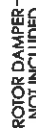
Job BOM				012629
Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic CORNER	1 Ea (1 ea)	100-Small Fab -	
20625A914	Dial Indicator Attchmnt Agd-2 Dial 60	1 Ea (1 ea)	100-Small Fab -	151056
5416K41	SS Hose Clamp 3.5" Dia. 45	1 Ea (1 ea)	100-Small Fab -	131311
90108A417	Flat Washer 3/8" Plated 62	2 Ea (2 ea)	100-Small Fab -	044121 044125
91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread 70	1 Ea (1 ea)	100-Small Fab -	044121
92845A245	18-8 Ss Extended (Dog) Point Socket Set Screw 10-24 Thread, 1/2" Length 54	2 Ea (2 ea)	100-Small Fab -	131313
93839A815	Hex Nut 3/8-24 Unf 56	2 Ea (2 ea)	100-Small Fab -	44124
97135A210	Nylon Lock Nut, 1/4-20 58	1 Ea (1 ea)	100-Small Fab -	044120
98404A250	Quick Release Pin, Ø5/16 X 1 43	1 Ea (1 ea)	100-Small Fab -	175979
98404A959	Quick Release Pin, Ø1/4 X 1 42	1 Ea (1 ea)	100-Small Fab -	175981
AGD-2	1" Dial Indicator 0" to 1" Range 78	1 Ea (1 ea)	100-Small Fab -	5223690
RBT18520-1	Lift Device Frame 145B	1 pcs (1 ea)	100-Small Fab -	217490
RBT18520-11A	Weight Assembly 145B	1 pcs (1 ea)	100-Small Fab -	132092
RBT18520-15	Clevis Bracket 146	1 pcs (1 ea)	100-Small Fab -	223387
RBT18520-16	Indicator Bracket 146	1 pcs (1 ea)	100-Small Fab -	219239
RBT18520-5	Weldment 145B	1 pcs (1 ea)	100-Small Fab -	206724
RBT18520-7	Pivot Bar Weldment 146	1 pcs (1 ea)	100-Small Fab -	105544 194300
RBT18520-9A	Extension Assembly 145B	2 pcs (2 ea)	100-Small Fab -	194494
				612x1 174x1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	10164	1	5	0
	20625A914	1	3	0
	5416K41	1	13	0
	90108A417	2	78	0
	91259A583	1	6	0
	92845A245	2	11	0
	93839A815	2	37	0
	97135A210	1	23	0
	98404A250	1	8	0
	98404A959	1	2	0
	AGD-2	1	2	0
	RBT18520-1	1	4	0
	RBT18520-11A	1	3	0
	RBT18520-15	1	13	0
	RBT18520-16	1	12	0
	RBT18520-5	1	3	0
	RBT18520-7	1	3	0
	RBT18520-9A	2	6	0

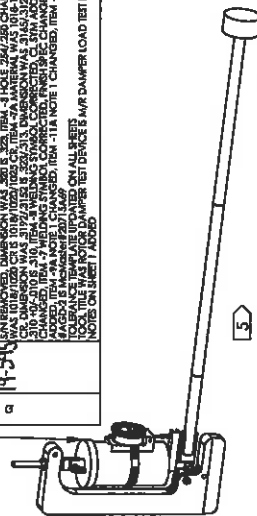
Part Specifications

Specifications could not be found.

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**ROTOR DAMPER
NOT INCLUDED—**



NOTE:

- 1) CALIBRATED UPON CUSTOMER REQUEST.
- 2) APPLY RED THREAD-LOCKER LOCITITE 283/262 ON THREADS OF ITEM -12 THEN ASSEMBLE WITH ITEM -12A AND REMOVE EXCESS
- 3) TORQUE ITEM -12A TO 80-85 IN-LBS
- 4) INSTALL ITEM -17 HAND TIGHT
- 5) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

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ASST QTY	ASST QTY	ASST QTY	ASST QTY	B/O	Part #	Description	Material	EIO INFORMATION OR SPECIFICATIONS	PQ.
				-1	1	FRAME	6061/7075		2
				-3		TOP BOLT TAB	9018P10201035 CR		3
				-3	1	TOP BOLT WELDMENT			4
				-5A		ALL THREAD	STEEL	3/8-24 (McMaster#P032A131) MOOFRED	5
				B/O -6	2	LAWN NUT	STEEL	3/8-24 GRADE 8 (McMaster-CARR #P283A115)	1
				B/O -6A	2	FLAT WASHER	STEEL	6218 (McMaster-CARR #P0108A117)	1
				-7	1	PIVOT BAR WELDMENT			6
				-7A		PIVOT BAR TAB	1018P10201035 CR		7
				-8		TUBE	AS13 TYPE 3 DOM TUBING		8
				-9		EXTENSION	AS13 TYPE 3 DOM TUBING		9
				-9A	2	EXTENSION ASSEMBLY			10
				B/O -10		SOCKET HEAD SET SCREW	STEEL	7/16-24 X 1-1/2 (McMaster-CARR #P1215A073)	10 & 12
				-11		WRIGHT	BA55 360		11
				-11A	1	WRIGHT ASSEMBLY			12
				B/O -12	1	SOCKET HEAD SHOULDER BOLT	STEEL	1/4-20 X 7/16 .0316 X 1 SHOULDER (McMaster-CARR #P1259A088)	1
				B/O -12A	1	NYLON LOCK NUT	STEEL	1/4-20 (McMaster#P135A210)	1
				B/O -13	1	GRICK RELEASE PIN	S.S.	6114 X 1 (McMaster#P80AA059)	1
				B/O -14	1	GRICK RELEASE PIN	S.S.	6817/16 X 1 (McMaster#P96A4320)	1
				-15	1	CLAMP BRACKET	6061/7075		13
				-16	1	INDICATOR BRACKET	6061/7075		14
				B/O -17	2	SOCKET HEAD SET SCREW (DOO POINT)	S.S.	#10-24 X 1/2 (McMaster-CARR #P83A4345)	1
				B/O -18	1	HOSE CLAMP	S.S.	681-1/16 TO 68 X 1/2 (McMaster-CARR # 841641)	1
				B/O -19	1	1 in DIA INDICATOR	(McMaster#P2715A07) Δ		15
				B/O -21	1	FLAT BACK FOR DIAL INDICATOR	FOR ASD GROUP 2 DIAL INDICATOR (McMaster-CARR #P263A914)		1
				B/O -23	1	LARGE PIVOT CASE	(ASD GROUP 10114)		N/A
ASST QTY	ASST QTY	ASST QTY	ASST QTY	B/O	Part #				

[illegible]

TITLE		M/R DAMPER LOAD TEST DEVICE	
OWNER NO.	RBT1 8520		QTY 2
DRAWING BY: COOLE		UNLESS OTHERWISE SPECIFIED	
CHECKED: MACKOVIAK		ALL DIMENSIONS ARE IN INCHES	
DESIGNED: ANDERSON		FRACTIONS ARE TO BE SHOWN AS	
DATE: 1/27/85		ANGLES 90°	
SCALE: N/A		TOLERANCES ARE	
APPROVED: LINDSAY		FRACTIONS	
DATE: 1/27/85		DECIMALS	
SHEET OF 17		SURFACES = 150	
		1. HOLE ± .010 ON CENTER	
		2. ALL DIMENSIONS APPLY	
		3. HOLE LOCATIONS TO ADY PER	
		USED ON MODEL	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By			
		Lead hand / Supervisor		QC / QA Coordinator	



Chicago Dial Indicator Co.
1372 Redeker Road
Des Plaines, IL 60016
ISO Registered Firm

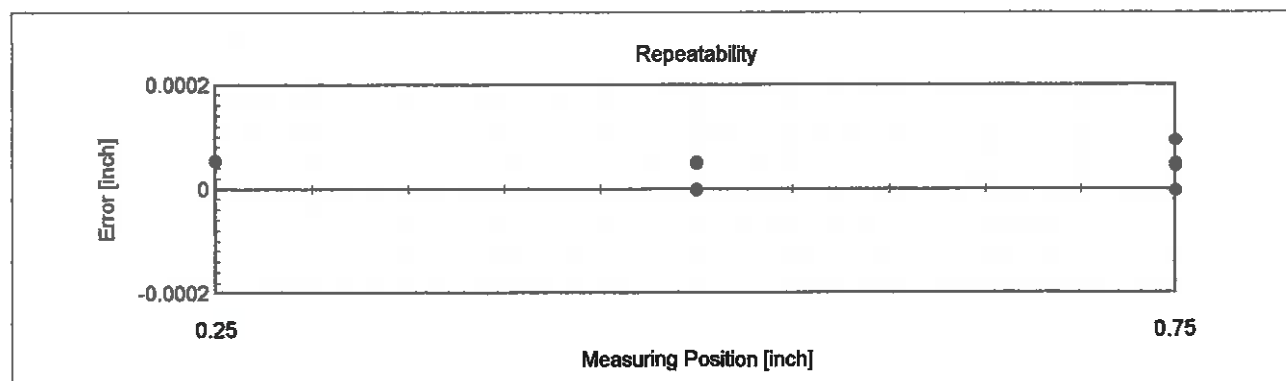
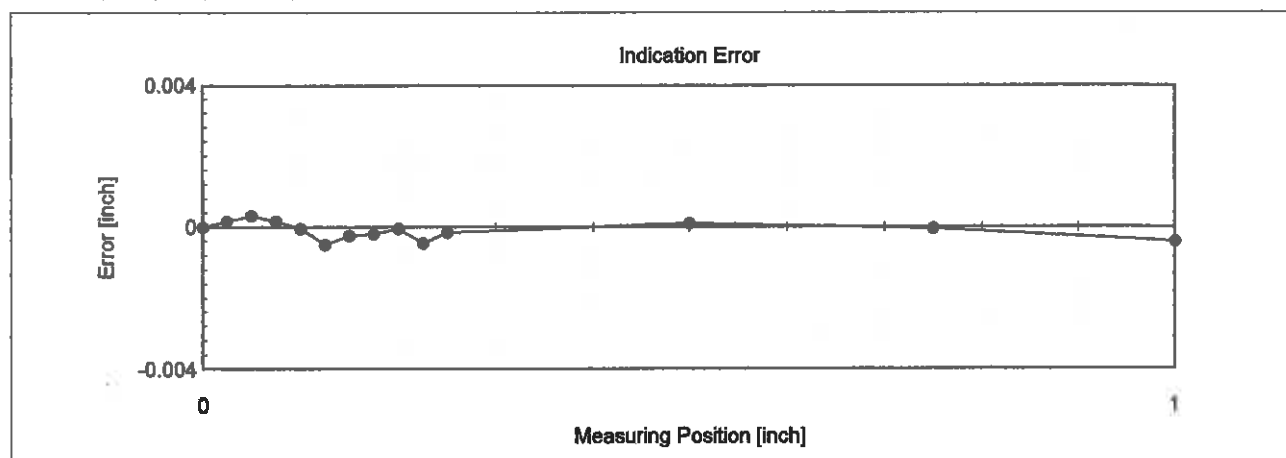
Factory Certificate of Calibration

Model No.	26104BJ-HC	Name of Inspection Standard	CDI Mechanical Standard
Serial No.	191010289	Unit	inch
Certificate No.	73138	Scale Interval	0.001 inch
		Measuring Range	1 inch
		Reference Point	0 inch
		End Point	1 inch

N.I.S.T. No. 821/268795-03

Inspection Item Name	Result	Permissible Value	Judgment
First 2-1/3 Revolutions	-0.0005027 inch	± 0.001 inch	GO
First 10 Revolutions	-0.0005027 inch	± 0.002 inch	GO
First 20 Revolutions	_____	_____	N/A
Hysteresis	_____	_____	N/A
Repeatability	+0.0000913 inch	± 0.0002 inch	GO

Inspection Item Name	Judgment
Inspection of Function and Appearance	GO



Repeatability is taken at three positions, with five readings at each position.

Phone: 847-827-7186
Fax: 847-827-0478
Website: www.dialindicator.com

Date _____
Put into service date, provided by end user

Signature: *Maria C*